

Date: Wednesday, 1/23/2008 11:39:13 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DOUBLER
Job Number	: 36929		
Estimate Number	: 11593		
P.O. Number	:	Part Number	: D2912
This Issue	: 1/23/2008 S.O. No. :	Drawing Number	: D2912 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: A
Previous Run	: 31829	Material	:
Written By	:	Due Date	: 1/30/2008 Qty: 40 Um: Each
Checked & Approved By	: <u>1/23/08 0123</u>		
Comment	: Est B 02.11.12 Re-format; Incorporated D2911 and D2912 K J Est Rev:C Now on Waterjet 07-01-23 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S090	6061-T6 .090 Sheet
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Comment: Qty.: 0.1030 sf(s)/Unit Total : 4.1202 sf(s)
 6061-T6 .090 Sheet
 Material: Sheet 6061-T6 x 0.090" thick
 (M6061T6S.090)
 Batch: 19295 IB 8-1-25

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D2912
 Dwg Rev: A IB 8-1-25
 Prog Rev: A
 2-Deburr if necessary IB 8-1-25

(41)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

5 08/01/25 (41) counts

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 08/02/08

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/23/2008 11:39:13 AM
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Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form on CNC brake as per Dwg D2910, D2911, D2912 and QSI 034 4.1

SB 02/01/31

(41)

6.0

CHEMICAL TREAT

CHEMICAL TREATMENT



Comment: CHEMICAL TREATMENT

M-h

08/02/06

(41)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/02/06 (41)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST53

AS 08/02/07 (41)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/02/08

(41)

Job Completion



2008/2/07

(41)

W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

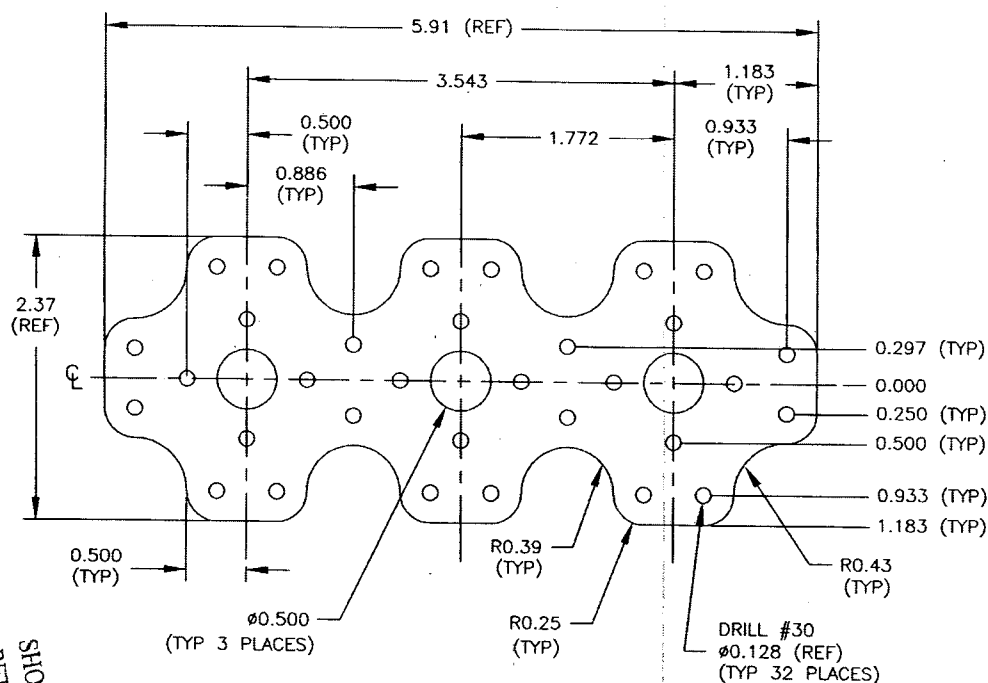
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
99.09.28 DS



FLAT PATTERN

BENDING DETAIL

R1.51

NO. 36929
WORK ORDER
SUBJECT TO AMENDMENT
WITHOUT NOTICE
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

MATERIAL: 6061-T6 SHEET (QQ-A-250/11) 0.091" THICK
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

A	99.09.07	NEW ISSUE
DESIGN	CP	DRAWN BY RF
CHECKED	CP	APPROVED
DATE	99.09.07	TITLE DOUBLER
		DART DART AEROSPACE USA, INC. BELLEVUE, WA
		DRAWING NO. D2912
		REV. A SHEET 1 OF 1
		SCALE 1:1